



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4894-1
Job Sheet 168173



Part No: D4894-1

Job Qty: 2 ea

Part Name: Fwd Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/10/17

Job Tracking No:

Due Date: 12/27/17

Created By: Mario Poulin

Type: **SOLD**

Description:

Customer: Pacific Helicopters Pty - Asia Pacific (CPAC102)

PO Box 342, Goroka, Eph Papua, , 441 Papua New Guinea ph:011 675 732 1833 fx:011 (675) 5321503.

Note: DWG REV B SHEET 1 IPP REV:A 13.05.27 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		12/26/17	0.00	0.00	Start Up Waterjet1		de
100	Waterjet	2 pcs		12/26/17	0.00	4.76	Waterjet1		de
110	QC	2 pcs		12/26/17	0.00	0.00	QC2		de
114	Mill Conv	2 pcs		12/26/17	0.00	3.13	Mill Conv 1		J.C.L. 17-02-08
116	QC	2 pcs		12/26/17	0.00	0.00	QC2		J.C.L. 17-02-08
120	QC	2 pcs		12/26/17	0.00	0.00	QC8		mk 17/12/11
130	HandFinish	2 pcs		12/26/17	0.00	0.39	HandFinish1		2017-12-12 JSC
131	Powdercoat	2 pcs		12/27/17	0.00	0.29	Powdercoat1		BK 17-12-12
132	QC	2 pcs		12/27/17	0.00	0.00	QC3		38 DAS
140	QC	2 pcs		12/27/17	0.00	0.00	QC5		Sm 38
150	Packaging	2 pcs		12/27/17	0.00	0.00	Packaging3		9-89
160	QC21-SA	2 Ea		12/27/17	0.00	0.00	QC21		st 40

M 138467

START: 2:30

OV.T: 3:00

FINISH: 3:00

Job Allocations

DEC 5 2017

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B1.000X06.000	9	60	0	0

138037

9.5

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐
Part No. _____	
NCR No. _____	
Date: _____	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Q

Step #: _____

Description Work Order Deviation

Root Cause	
Environment ☐	No Re-verification ☐
Design ☐	Operator ☐
Doc/Data ☐	Offset/Setup ☐
Equip/Tooling ☐	Supplier ☐
Handling/Pre ☐	Training ☐
Material ☐	Use for Testing ☐
Internal Transport ☐	Poor Information ☐
Tribal Knowledge ☐	Rushing ☐
LOA ☐	Product Improvement ☐
Substation ☐	Process Improvement ☐
Past Expiry Date ☐	Manufacturing Process ☐
Misidentified ☐	Past Due ☐

OTHER : _____

DART
AEROSPACE
S016733



Fwd Beam

D4894 - 1

PART NO:
Revision:
Operation:
Change No:

Start up Operation

Mfg Date: 12/04/17
Job No: 168173

Engineering ☐
Quality ☐
Other ☐

(1042) Approval

Completed By

/ Supervisor
Verification

Coordinator
Initial

Wrong
Dimensions
tolerance
t
Missing

Part Moved
Drawing
Finish
Misread
Turning Sequence

DART AEROSPACE LTD		Work Order:	168173
Description: Fwd Beam		Part Number:	D4894-1
Inspection Dwg: D4894 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.63	+/-0.030	52.63	1		V: 02-02	
19.75	+/-0.030	19.75	1		Tape	
11.00	+/-0.030	11.00	1			
6.50	+/-0.030	6.50	1			
0.65	+/-0.030	0.665	1			
3.50	+/-0.030	3.492	1			
1.50	+/-0.030	1.508	1			
6.50	+/-0.030	6.50	1			
4.35	+/-0.030	4.35	1			
2.85	+/-0.030	2.866	1			
3.80	+/-0.030	3.80	1			
12.16	+/-0.030	12.16	1			
4.00	+/-0.030	4.00	1			
14.25	+/-0.030	14.25	✓		Tape	
0.60	+/-0.030	0.616	✓		Caliper	JCL-08
36.38	+/-0.030	36.375	✓		Tape	
Ø0.129	+0.005/-0.001	0.129	✓		Caliper	JCL-08
1.00	+/-0.030	1.003	✓			
0.60	+/-0.030	0.616	✓			
2.300	+/-0.010	2.300	✓			
0.75	+/-0.030	0.750	✓			
1.800 Pitch	+/-0.005	1.800	✓			
3.600	+/-0.005	3.600	✓			
Ø0.377	+0.006/-0.001	0.378	✓			

Measured by: ac J.C.L.	Audited by: JCL	Preliminary Approval:
Date: 17/12/02 17-12-08	Date: 17/12/11	Date:

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	
B	14.09.17	Dwg Rev updated	KJ	